

Date: Tuesday, 13/05/2008 10:09:25 AM  
 User: Linda Lacelle

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services			Drawing Name	: DOUBLER		
Job Number	: 39185			Part Number	: D3144119		
Estimate Number	: 10636			Drawing Number	: D3144 REV C		
P.O. Number	:			Project Number	: N/A		
This Issue	: 13/05/2008 S.O. No. :			Drawing Revision	: C		
Prsht Rev.	: NC			Material	:		
First Issue	: / / Type : SMALL /MED FAB			Due Date	: 30/05/2008 Qty: 4 Um: Each		
Previous Run	: 39185						
Written By	:						
Checked & Approved By	:						
Comment	: Est. A04.11.29 New issue KJ/RF Est Rev:B 08-05-12 now made on water jet DD verified by:EC						

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M2024T3S032	2024-T3 .032 sheet 
<b>Comment:</b> Qty.: 0.0735 sf(s)/Unit Total : 0.2940 sf(s) 2024-T3 .032 sheet Batch: <u>106 272</u> <u>HB</u> <u>8-5-14</u>		
2.0	WATER JET	FLOW WATER JET 
<b>Comment:</b> FLOW WATER JET 1-Cut as per Dwg D3144 Dwg Rev: <u>C</u> <u>HB</u> <u>8-5-14</u> <u>6</u> Prog Rev: <u>C</u>		
2-Deburr if necessary <u>HB</u> <u>8-5-14</u>		
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE 
<u>HB</u> <u>8-5-14</u>		
<b>Comment:</b> INSPECT PARTS AS THEY COME OFF MACHINE		
4.0	QC8	SECOND CHECK 
<u>508/05/14</u> <u>(X6)</u>		
<b>Comment:</b> SECOND CHECK		
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1 
<u>1/1</u> <u>Done at step 5 08/05/14</u> <u>2/2</u>		
<b>Comment:</b> SMALL & MEDIUM FAB RESOURCE 1 Deburr		

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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOUBLER

Job Number: 39185

Part Number: D3144119

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

MF 08/05/14 ⑥

7.0 POWDER COATING

POWDER COATING



M105642

30 min  
15/05/2008  
S.254 15.08  
#1 314.5 F  
#2 339.8 F  
#3 344.9 F  
#4 D3144119 F

Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

START TIME: 2:15

OVEN TEMPERATURE: 320° F

FINISH TIME: 3:02

m-1 08/05/

8.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08-05-15

X.6

9.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST143

AS 08/05/16 X6

10.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/05/2008

Job Completion



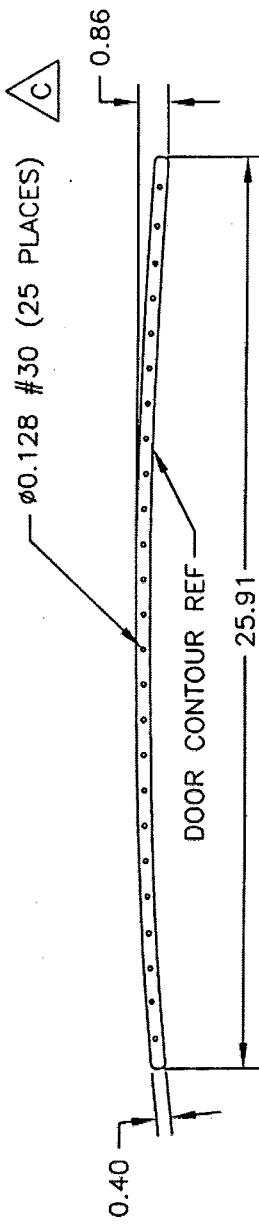
MF 08-05-16



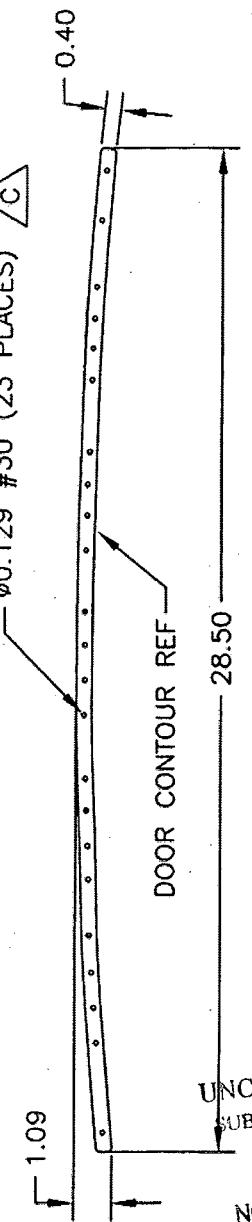
DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED <i>[initials]</i>	APPROVED <i>[initials]</i>	DRAWING NO. D3144 REV. C SHEET 1 OF 9
DATE 05.10.19		TITLE DOUBLER SCALE 1:5
A	02.04.22	NEW ISSUE
B	04.09.17	ADDED D3144-105/-107/-109/-111/-115/-121/-123; MODIFY D3144-1
C	05.10.19	ADD D3144-15; Ø0.129 WAS Ø0.098

RELEASED

05.11.14 *[initials]*



**D3144-1 DOUBLER (FOR D412-694-03)**  
REPLACES PREMIER P/N B30-23000-191



**D3144-3 DOUBLER (FOR D412-694-01)**  
REPLACES PREMIER P/N B30-23000-193

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**D3144-1/-3 NOTES:**

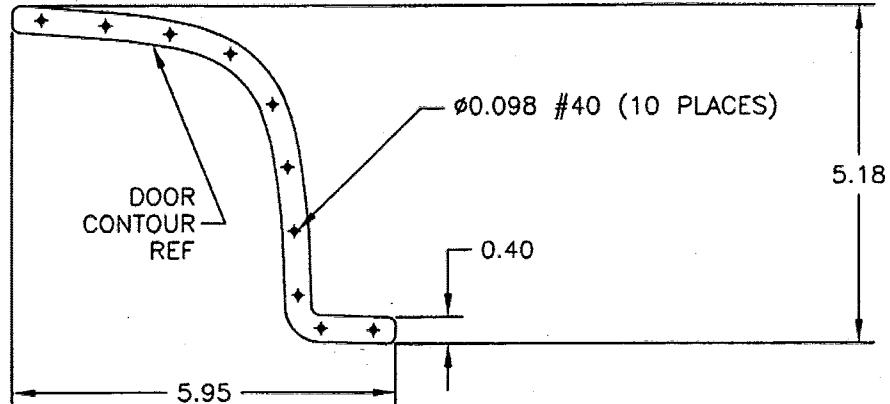
- 1) MATERIAL: 2024-T3 SHEET (QQ-A-250/4) 0.032 THICK (REF DART SPEC M2024T3S.032)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) POWDER COAT BLACK SANDTEX (4.35.7) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 7) MACHINE PER DRAWING "D3144-C1.DWG"

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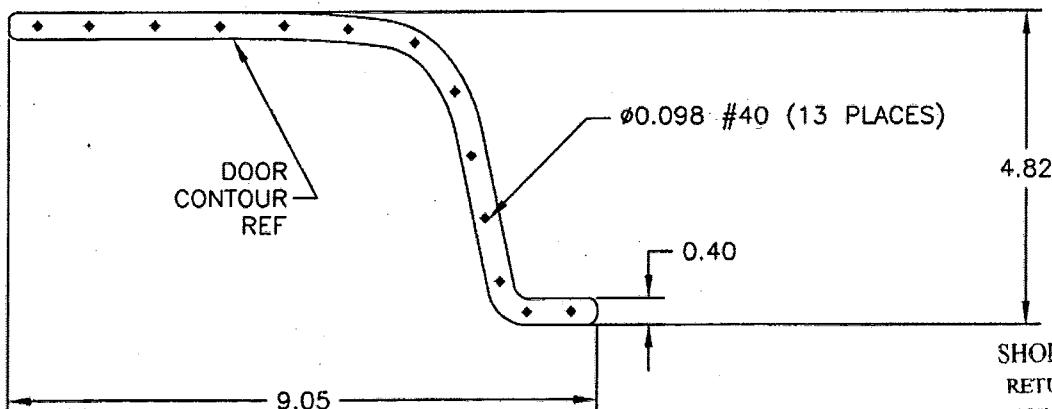
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DATE 05.10.19		TITLE DOUBLER	SCALE NTS



**D3144-5 DOUBLER**  
REPLACES PREMIER P/N B30-23000-195



**D3144-7 DOUBLER**  
REPLACES PREMIER P/N B30-23000-197

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**D3144-5/-7 NOTES:**

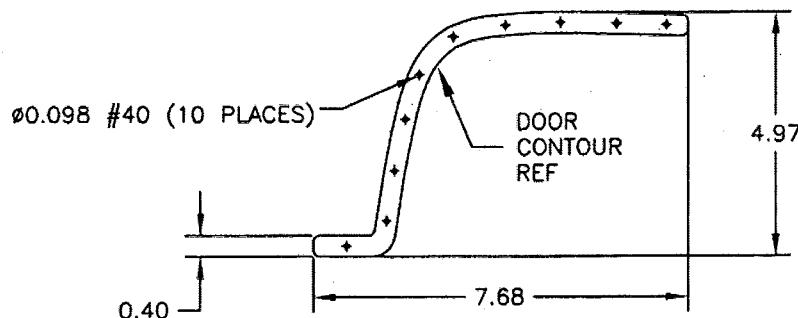
- 1) MATERIAL: 2024-T3 SHEET (QQ-A-250/4) 0.032 THICK (REF DART SPEC M2024T3S.032)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT BLACK SANTEX (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 6) MACHINE PER DRAWING "D3144-C2.DWG"

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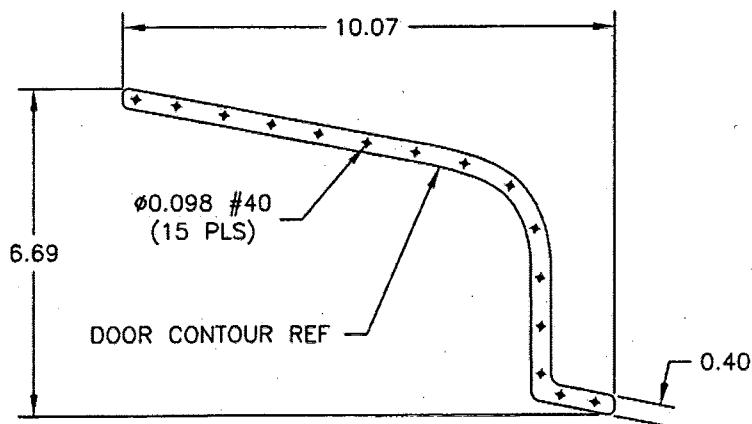
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DATE 05.10.19		TITLE DOUBLER	SCALE NTS



**D3144-9 DOUBLER**  
REPLACES PREMIER P/N B30-23000-199



**D3144-11 DOUBLER**  
REPLACES PREMIER P/N B30-23000-203

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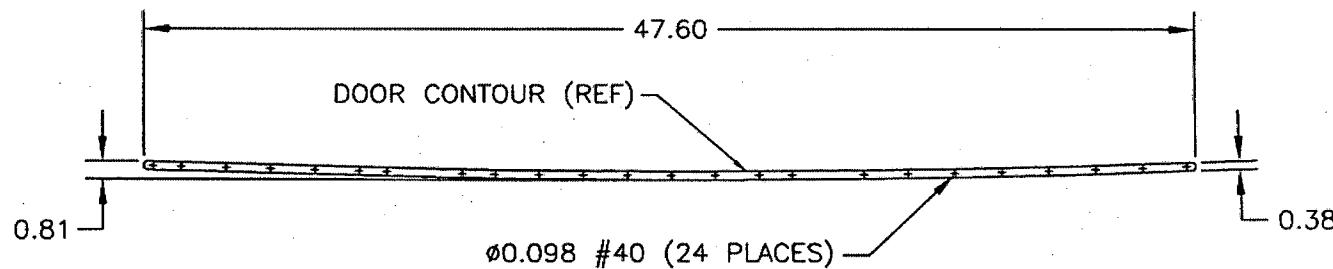
**D3144-9/-11 NOTES:**

- 1) MATERIAL: 2024-T3 SHEET (QQ-A-250/4) 0.032 THICK (REF DART SPEC M2024T3S.032)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT BLACK SANTEX (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 6) MACHINE PER DRAWING FILE "D3144-C3.DWG"

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*05.11.14*

*[Signature]*



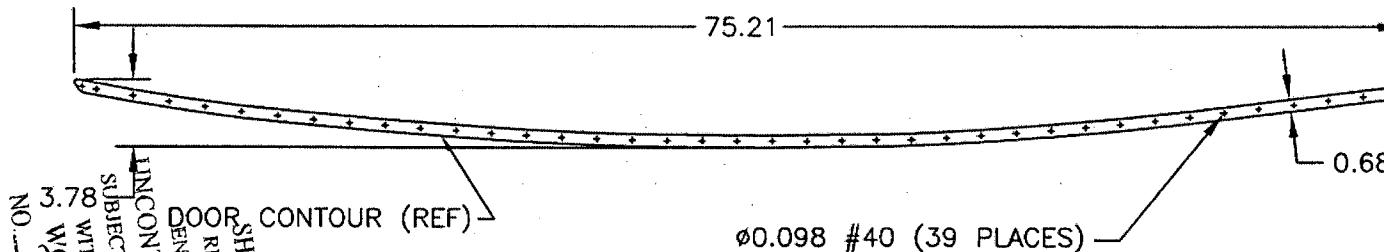
**D3144-15 DOUBLER**  
SCALE 1:8



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DATE 05.10.19	TITLE DOUBLER	REV. C SHEET 4 OF 9 NTS SCALE



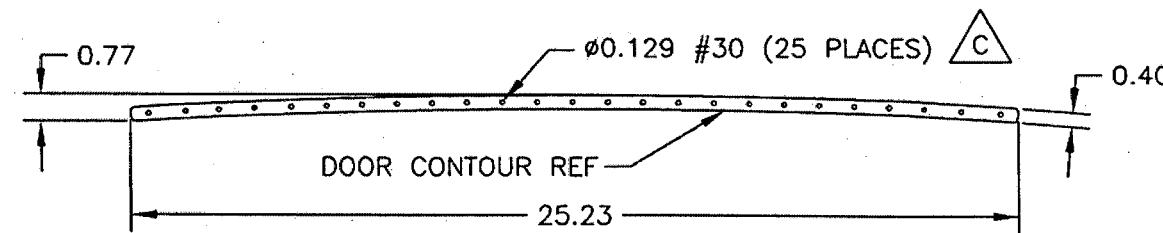
**D3144-13 DOUBLER**  
SCALE 1:10

REPLACES PREMIER P/N B30-23000-211

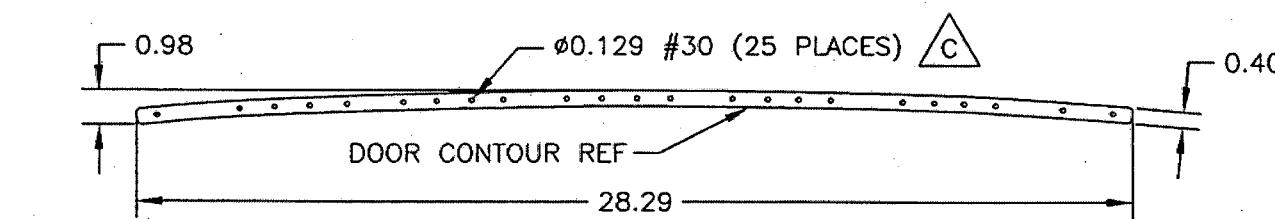
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**D3144-13 NOTES:**

- 1) MATERIAL: 2024-T3 SHEET (QQ-A-250/4) 0.020 THICK (REF DART SPEC M2024T3S.020)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT BLACK SANTEX (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 6) MACHINE PER DRAWING FILE "D3144-C4.DWG"



D3144-119 DOUBLER (FOR D412-694-04)



D3144-123 DOUBLER (D412-694-02)

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D3144-119/-123 NOTES:

- 1) MATERIAL: 2024-T3 SHEET (QQ-A-250/4) 0.032 THICK (REF DART SPEC M2024T3S.032)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT BLACK SANTEX (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 6) MACHINE PER DRAWING FILE "D3144-C5.DWG"

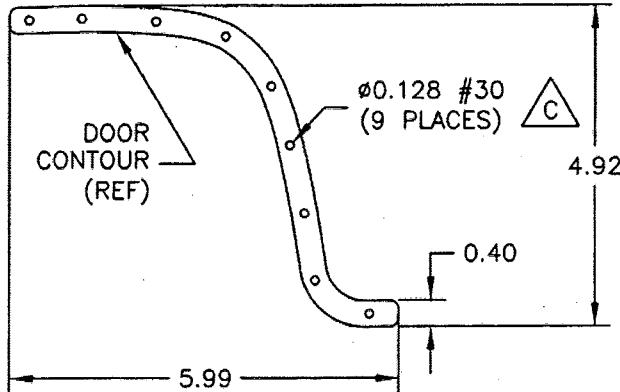
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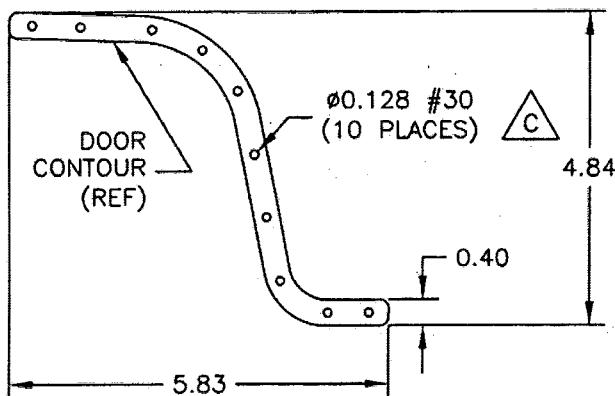
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DATE 05.10.19	TITLE DOUBLER	HAWKESBURY, ONTARIO, CANADA	
		SHEET 5 OF 9	NTS



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DATE 05.10.19		TITLE DOUBLER	SCALE NTS



D3144-105 DOUBLER (FOR D412-694-03)



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D3144-117 DOUBLER (FOR D412-694-04)

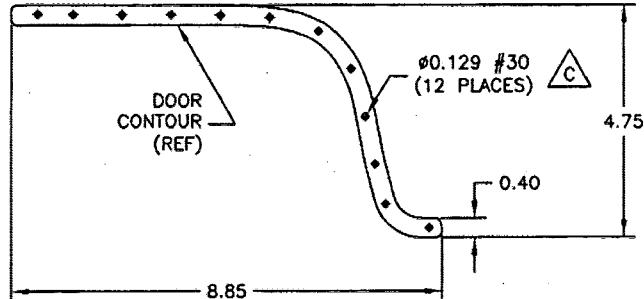
D3144-105/-117 NOTES:

- 1) MATERIAL: 2024-T3 SHEET (QQ-A-250/4) 0.032 THICK (REF DART SPEC M2024T3S.032)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT BLACK SANTEX (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 6) MACHINE PER DRAWING "D3144-C6.DWG"

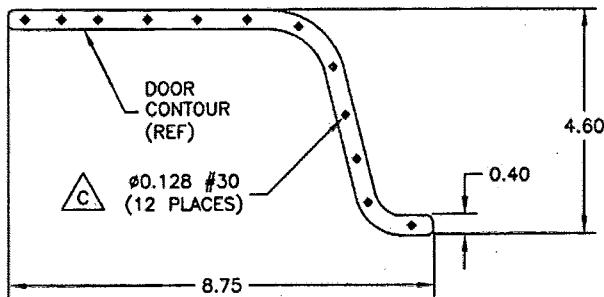
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DATE 05.10.19		TITLE DOUBLER	SCALE NTS



D3144-107 DOUBLER (FOR D412-694-03)



D3144-121 DOUBLER (FOR D412-694-04)

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05.11.14 *[initials]*

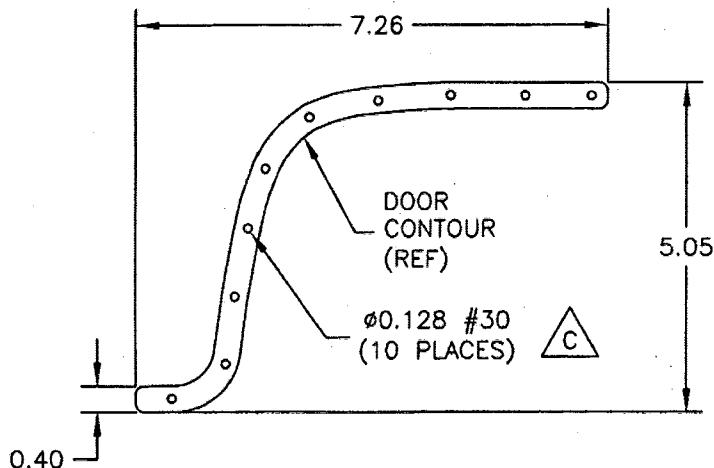
D3144-107/-121 NOTES:

- 1) MATERIAL: 2024-T3 SHEET (QQ-A-250/4) 0.032 THICK (REF DART SPEC M2024T3S.032)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT BLACK SANTEX (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 6) MACHINE PER DRAWING FILE "D3144-C7.DWG"

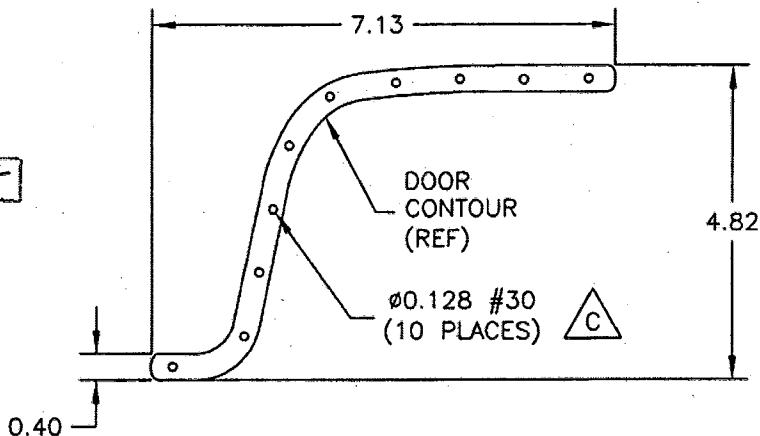
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DATE 05.10.19		TITLE DOUBLER	SCALE NTS

D3144-109 DOUBLER (FOR D412-694-01)**RELEASED**

05.11.14

D3144-115 DOUBLER (FOR D412-694-02)**D3144-109/-115 NOTES:**

- 1) MATERIAL: 2024-T3 SHEET (QQ-A-250/4) 0.032 THICK (REF DART SPEC M2024T3SI032)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT BLACK SANTEX (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 6) MACHINE PER DRAWING "D3144-C8.DWG"

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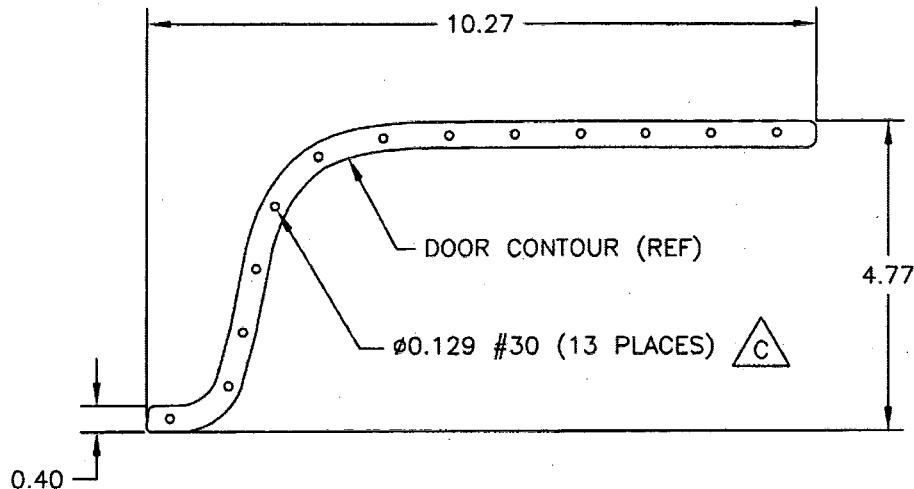
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DATE 05.10.19	TITLE DOUBLER	REV. C SHEET 9 OF 9 SCALE NTS

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05.11.14



D3144-111 DOUBLER (FOR D412-694-01/-02)

D3144-111 NOTES:

- 1) MATERIAL: 2024-T3 SHEET (QQ-A-250/4) 0.032 THICK (REF DART SPEC M2024T3S.032)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT BLACK SANTEX (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 6) MACHINE PER DRAWING "D3144-C9.DWG"

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DART AEROSPACE LTD	Work Order:	39185
Description: Doubler	Part Number:	D 3144-119
Inspection Dwg: D 3144-119 Rev: C		Page 1 of 1

## **FIRST ARTICLE INSPECTION CHECKLIST**

X First Article      Prototype

Measured by: HB  
Date: 8-5-14

<b>Audited by:</b>	<u> </u>
<b>Date:</b>	08/05/14

Prototype Approval:	<input checked="" type="checkbox"/>
Date:	1/1

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	